

5/17

DART AEROSPACE LTD	Work Order:	22929
Description: Spacepod Floor	Part Number:	D3187-1 D3187-2
Dwg: D3187 Rev. B	Qty:	ZG ZS

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <u>Dwg not required</u>	XJ	05.04.06	25
2	PG	Cut blank: (53.50" x 20.00") Issue PD Material: 6061-T6 (QQ-A-250/11) 0.050" thick (M6061T6S.050) D3187-1 per dwg Batch: GFT	U	05.04.06	25
3	RA	Cut & drill per template D3187-1T1 & Dwg D3187 Receive & inspect for transit damage	CJ	05/04/09	25
4	GA	Deburr	N/A ml	05-05-04	25
5	QC6	Inspect work up to Step 4	ml	05-05-04	25
6	FP	Acid etch and Alodine as per QSI 005 4.1			
7	FP	Powder Coat Black Sandtex (Ref. 4.3.5.7) per QSI 005 4.3			
8	QC3	Inspect Powder Coat			
9	GA	Cut D2986 Neoprene Foam per template D2986T1 Batch:			
10	GA	Attach Neoprene Foam using Contact Cement Note: D3187-1 or D3187-2 side as per Dwg D3187			
11	QC5	Inspect work to Step 10			
12	GA	Go to KP Stores Identify & Stock	ml	05-05-04	25

Rev	Date	Change 38.00	Revised By	Approved
A	03.04.22	New Issue	KJ/RF	
B	04.08.18	Revised Step Numbering	KJ/JLM	JLM

RELEASED
05/04/08/18

7	DC	Close w/o Inspect Level 21	XJ	05.05.10	26
---	----	----------------------------	----	----------	----

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

Part No:

PAR #:

Fault Category:

NCR: Yes No DQA:

Date:

NOTE: Date & initial all entries

QA: N/C Closed:

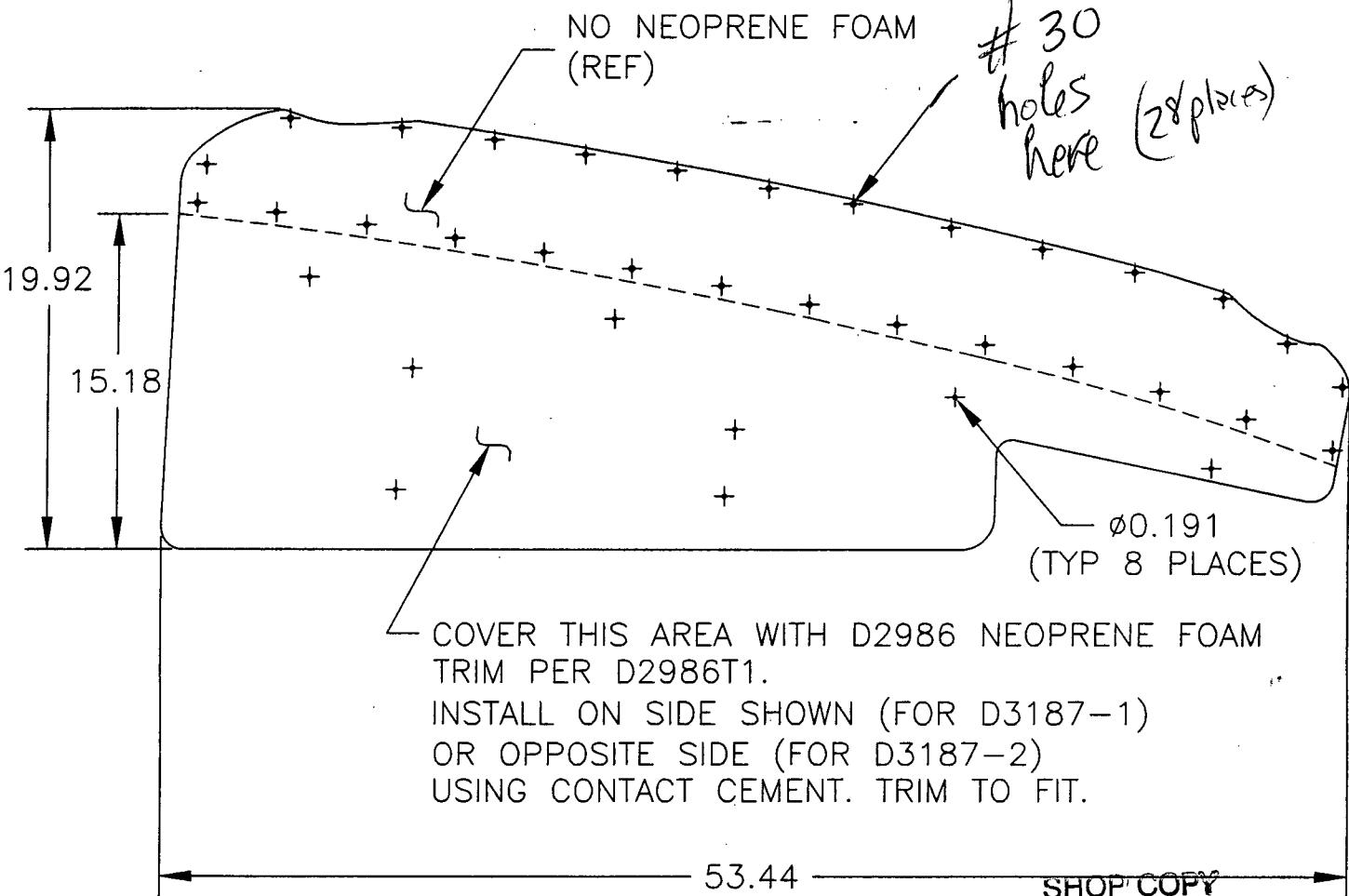
Date:



QACOPY
SHEET 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3187	SHEET 1 OF 1
DATE		TITLE	SCALE
03.05.16		SPACEPOD FLOOR	NTS
A	03.03.31	NEW ISSUE	
B	03.05.16	CHANGE SHAPE	

RELEASED
03.06.25



D3187-1/-2 SPACEPOD FLOOR

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK **WORK ORDER**
(REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANTEX (43.5.7) 22929
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 06, 2005
01:16 pm

Work Order No	:	0022929	Department Code:
Project Name	:	D3187-1	Burden Flags : NNNNNNNN
Project For	:	WK517	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3187-1	Invoice Number :
Description	:	Spacepod Floor	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	25	
Amount Done	:	0	Order Entry No :
Start Date	:	04-06-05	OE Value : 0.00
Est Finish Date	:	04-28-05	
Act Finish Date	:		Est Mark Up : 0.000%
Drawings Reqd	:	No	Actual Mark Up : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>	<hr/>	<hr/>	<hr/>	<hr/>	<hr/>
Burden	: 0.00	0.00	0.00		
<hr/>	<hr/>	<hr/>	<hr/>	<hr/>	<hr/>
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual	
Labour Hrs/Amount Done	: 0.00	0.00	
Profits/ (Loss)	: 0.00	0.00	
<hr/>	<hr/>	<hr/>	<hr/>

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0126542 SHIPPING MEMO 0300437

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>25 PCS</u>	<u>2007843</u>	<u>D3187-1</u>	<u>A</u>	<u>SPACEPOD FLOOR</u>	<u>B</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>AL 6061-T6 (QQ-A-250/11)</u>		<u>SAMUEL SPECIALTY</u>			<u>0058695-ATT'D</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 26 APRIL 2005

G.F.I. Q.C. REP.

199-05

**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 20 AVRIL 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058695 **# de commande SSMQ:** 840290
Customer's order #: **SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

otre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	6	.0500" x 48" x 144"	6061 T6		1896401
1	1	.0500" x 48" x 144"	6061 T6		1935201

Bien à vous,
Yours truly,

Jean Raymond

Commis à l'administration.
Administration Clerk.



INSPECTION CERTIFICATE



Corus Aluminium N.V.
A. Stoetlaan 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax 32 (0)15 30 27 94

DESCRIPTION : ALU COIL 6061-T6 MF QQA-250/11-AMS 4027 ASTM B209
DIMENSIONS : 48" X 0.05"
ARTICLE NO. :

CUSTOMER : Samuel Son & Company Ltd
547000
2360 Dixie road
MISSISSAUGA, ONTARIO L4Y 1Z7

YOUR ORDER NUMBER : A14524
OUR ORDER NUMBER : 16237/01
DOCUMENT NUMBER : V/0080064952

CAST NUMBER	COIL NUMBER	CHEMICAL COMPOSITION (%)						
-------------	-------------	--------------------------	--	--	--	--	--	--

	SI	FE	CU	MN	MG	CR	TI	ZN
	MIN 0,40		0,15		0,8	0,04		
	MAX 0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
1896401	001	0,67	0,3	0,22	0,08	1,0	0,15	0,01
OTHERS : EACH					MIN 0,05	MAX		
TOTAL :					MIN 0,15	MAX		

TEST-NUMBER	MECHANICAL PROPERTIES					
-------------	-----------------------	--	--	--	--	--

	1 N/MM ² = 1 MPa = 0,1 HBAR = 0,102 KG/MM ² = 0,145 KSI	
/A = REAR END	/M = MIDDLE	/V = FRONT END
		/O = RANDOM SAMPLING
	RM KSI	RP02 KSI
MIN	42	35
MAX		10
001 /A	49	39
001 /M	49	39
001 /V	48	39
		14

HEAD OF LABORATORY,
XAVIER SCHELTJENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions